

Work Order ID 63859

November 17, 2010 8:28:29 AM

Item ID: D3608-3

Revision ID:

Item Name: Upper Doubler

Start Date: 11/17/10 Start Qty: 1.00

Accept

Required Date: 11/17/10 Req'd Qty: 1.00



Reference:

Approvals: Process Plan:

u

Date:

Tooling:

Date:

Setup Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D3608

PC1

100



FLOW WATER JET

Waterjet

Memo

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

FLOW CNC Waterjet

1-Cut as per Dwg D3608
Dwg Rev: PC1
Prog Rev: PC1
2-Deburr if necessary

10-11-17

(1)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-11-17

Quality Control

120



QC8- Inspect parts - second check

0.00 - inspected to PC1

Day only

10-11-17 (70)

QC

Quality Control

Work Order ID 63859

November 17, 2010 8:28:29 AM



Page 2

Item ID: D3608-3

Accept



Setup

Start



Revision ID:

Item Name: Upper Doubler

Stop



Start Date: 11/17/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

150



Packaging

Packaging

Identify as per dwg & Stock Location:

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

U 10.11.17

0.00

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

ENR 1106

Memo

0.00

U 10.11.17

POSITIVE RECALL
EFFECTIVE 10.11.17 AUTH 6
RELEASED 10.11.17 DATE 10.11.22

Picklist Print

November 17, 2010 8:28:28 AM

Page 1

Work Order ID: 63859



Parent Item: D3608-3

Parent Item Name: Upper Doubler

Start Date: 11/17/10

Required Date: 11/17/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-03-26 JLM

IPP Rev:B 08-10-15 preliminary issue DD verified by:EC

IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP

Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E

10.11.17 as per PC1 dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	109.3000	0.7392	0.778105			<i>BS 10-11-17</i>

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	105.3	
115762	10.2	
115953	95.1	<i>115953</i>
MAT20	4	
113062	1.398	
115440	2.602	

①

DART AEROSPACE LTD	Work Order: 63859
Description: Upper Doubler	Part Number: D3608-3
Inspection Dwg: D3608-3, Rev: PC1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

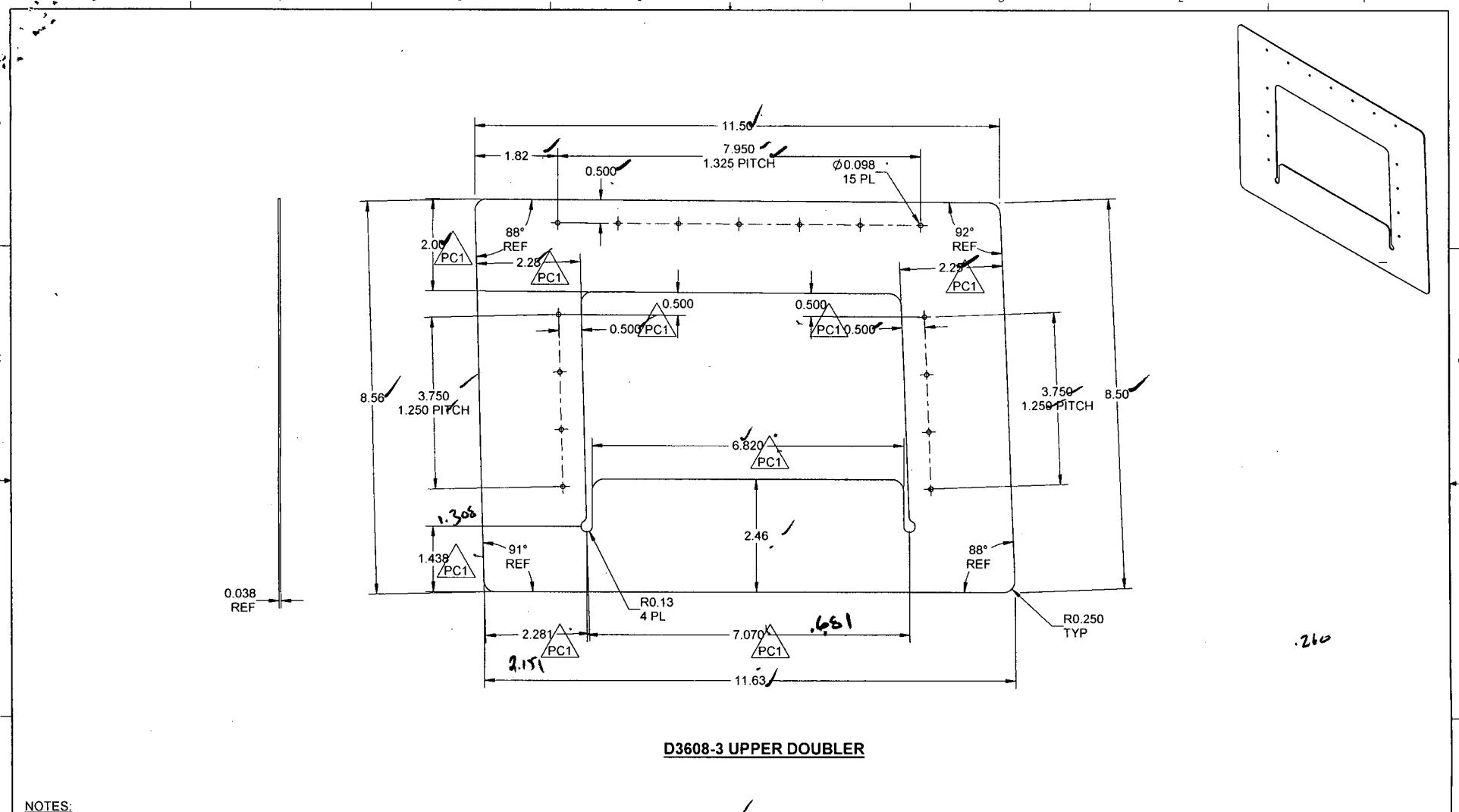
X First Article X Prototype

Measured by:	HB
Date:	10-11-17

Audited by:	S
Date:	10/14/17

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



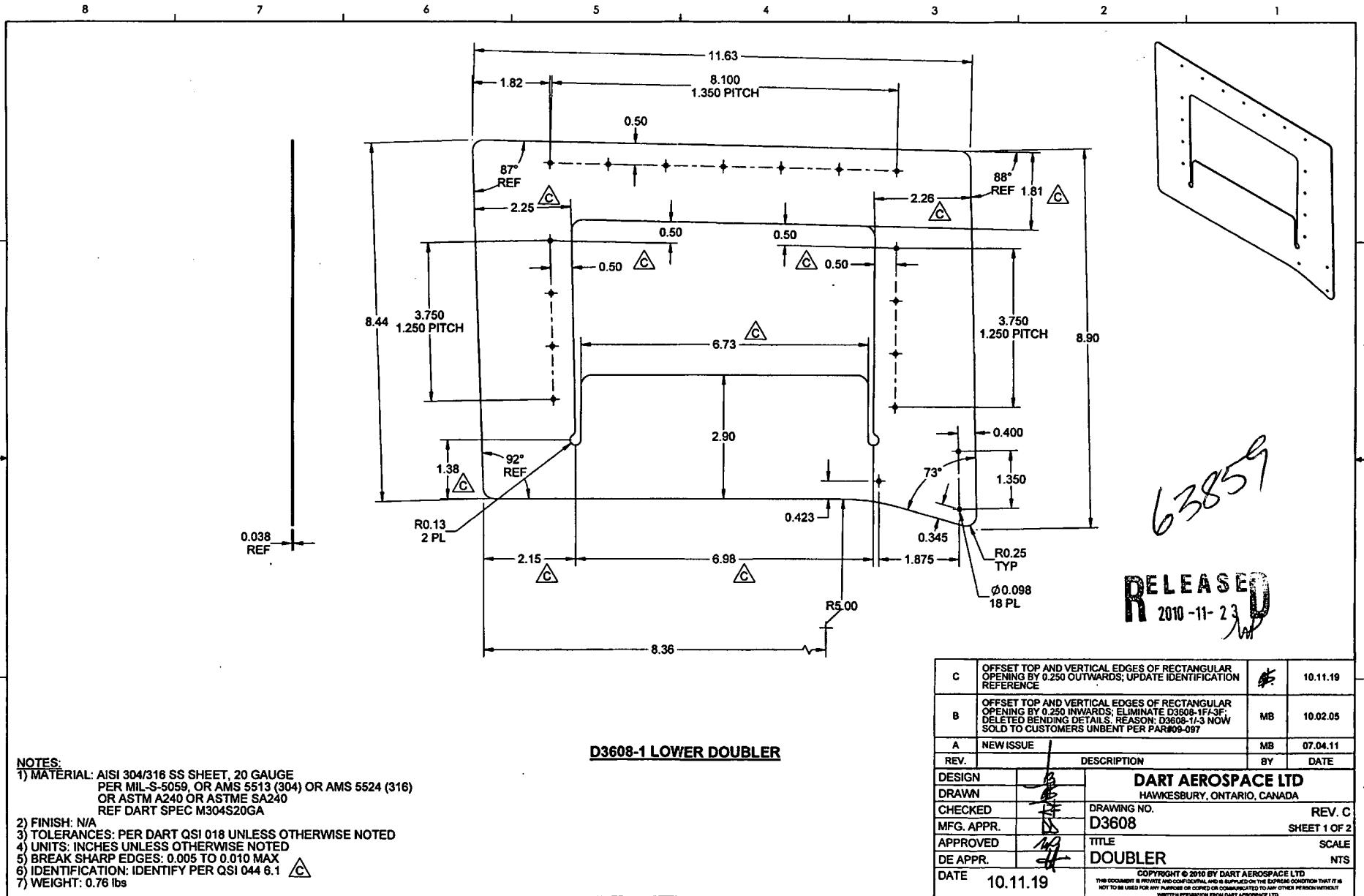
D3608-3 UPPER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTME SA240
REF DART SPEC M304SS20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.75 lbs

W0-63859

DESIGN	<u> </u>	DART AEROSPACE LTD
DRAWN	<u> </u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u> </u>	DRAWING NO. REV. PC1
MFG. APPR.	<u> </u>	D3608 SHEET 2 OF 2
APPROVED	<u> </u>	TITLE DOUBLER
DE APPR.	<u> </u>	SCALE NTS
DATE	10.11.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS PROVIDED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD



NOTES

1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA

2) FINISH: NA

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 0.76 lbs 

D3608-1 LOWER DOUBLER

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE		<i>SS</i>	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F1-3F; DELETED BENDING DETAILS. REASON: D3608-1-3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097		MB	10.02.05
A	NEW ISSUE		MB	07.04.11
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD			
DRAWN	HAWKESBURY, ONTARIO, CANADA			
CHECKED	DRAWING NO.		REV. C	
MFG. APPR.	D3608		SHEET 1 OF 2	
APPROVED	TITLE		SCALE	
DE APPR.	DOUBLER		NTS	
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